



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4931-5

Job Sheet 185027



Part No: D4931-5

Job Qty: 4 ea

Part Name: Engine Fitting (for B3e models)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEET 3 IPP REV:A NEW ISSUE 13-09-16 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/2/18	11/2/18	0.00	0.00	Start Up Machining-3		
100	Doosan	4 pcs	11/2/18	11/2/18	0.78	3.48	Doosan		
110	QC	4 pcs	11/2/18	11/2/18	0.00	0.00	QC2 Machining-3		
112	Mill Conv	4 pcs	11/2/18	11/2/18	0.00	1.65	Mill Conv 1		
115	QC	4 pcs	11/2/18	11/2/18	0.00	0.00	QC2 Machining-3		
120	QC	4 pcs	11/2/18	11/2/18	0.00	0.00	QC8 Machining-3		
130	Packaging	4 pcs	11/2/18	11/2/18	0.00	0.00	Packaging3-2		
140	QC21-SA	4 Ea	11/2/18	11/2/18	0.00	0.00	QC21		

Part Op 100 - Machine as per folio FB210
Descriptions: 112 - DRILL HOLES AS PER REQUIRED

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R2.000	303 Round Bar 2"	.6000 ft (.15 ea)	90-Start up Operation	50 / 80 / 10

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R2.000	1	29	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 10/22/18 9:06 AM Dart.lajeunesse.marie

Container No: S135445



Part: D4931-5

Job No: 185027

Serial No/Batch: S135445

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/06/18

0,333

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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DART AEROSPACE LTD		Work Order:	185027
Description: EAPS P2 Engine Fitting		Part Number:	D4931-5
Inspection Dwg: D4931 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1-1/16-12 UN 2A	N/A					
37°	+/-0.5°	37.0				
0.185	+/-0.010	.185				
0.315	+/-0.010	.314				
0.424	+/-0.010	.424				
0.250	+/-0.010	.250				
0.938	+/-0.010	.944				
1.927 Ref	+/-0.010	1.932				
0.25	+/-0.030	.254				
0.13	+/-0.030	.126				
0.907	+/-0.010	.904				
0.078	+/-0.010	.081				
Ø0.063	+0.004/-0.001	.063				
0.13 x 45°	+/-0.030 x +/-0.5°	.13 x 45°				
0.34	+/-0.030	.342				
0.25	+/-0.030	.250				
Ø0.238	+0.005/-0.001	0.238				
35°	+/-0.5°	35.0				
0.532	+/-0.010	0.532				
1.063	+/-0.010	1.06				
0.513	+/-0.010	.512				
0.749	+/-0.010	.748				
1.025	+/-0.010	1.025				

Measured by: JL	Audited by: [Signature]	Preliminary Approval:
Date: 18-12-6 / 18/12/10	Date: 18/12/11	Date:

Rev	Date	Change	Revised by	Approved
A	14.06.24	New Issue	KJ	[Signature]

